

Date: Tuesday, 05/05/2009 4:00:38 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 47746	
Estimate Number : 12949	
P.O. Number :	Part Number : D3259042
This Issue : 05/05/2009 S.O. No. :	Drawing Number : D3249 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 46974	Material :
Written By :	Due Date : 12/05/2009 Qty: 5 Um: Each
Checked & Approved By : <u>JUL 09.05.05</u>	
Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Assembly Kit

2.0	D32591	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 panel
 Batch: B47188 (44) B47850 (14) EF 09/06/05

3.0	D32594	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Doubler
 Batch: B47190 EF 09/06/05

4.0	D32595	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Spacer
 Batch: B47191 EF 09/06/05

5.0	D32597	Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Door
 Batch: B42192 (14) B47851 (44) EF 09/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 4:00:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 47746

Part Number: D3259042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D31615	Hinge 9.9"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Hinge 9.9"

Batch: M110625 B48375

7.0	D32601	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spring

Batch: B47852

8.0	127H5	HALF GROMMET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

HALF GROMMET

Batch: M111451

9.0	250018C3Y	RIGHT RECEPTACLE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

RIGHT RECEPTACLE

Batch: M111729 M105932

10.0	2501W20020C3Y	STUD
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

STUD

Batch: M110118

11.0	MS20426AD44	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

Batch: M15541

12.0	MS20470AD34	Rivet, Universal Head
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Comment: Qty.: 36.0000 Each(s)/Unit Total : 180.0000 Each(s)

Rivet, Universal Head

Batch: M15541

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 4:00:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 47746

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 50.0000 Each(s)

Rivet

Batch: M19682

EP 09/06/05

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3259-041 as per Dwg D3259 .
Note:Keep .040" Gap all around door.

EP 09/06/05 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-05 (5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: ST183

SS 09/06/08 (MS)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08 (J)

Job Completion



MF
09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

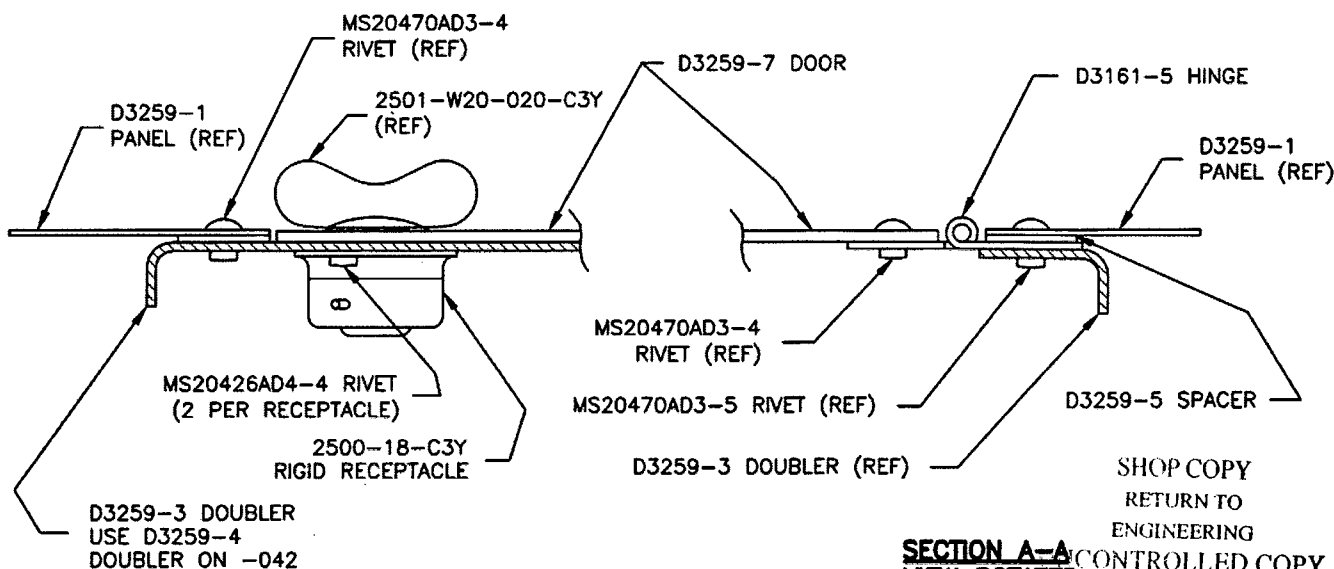
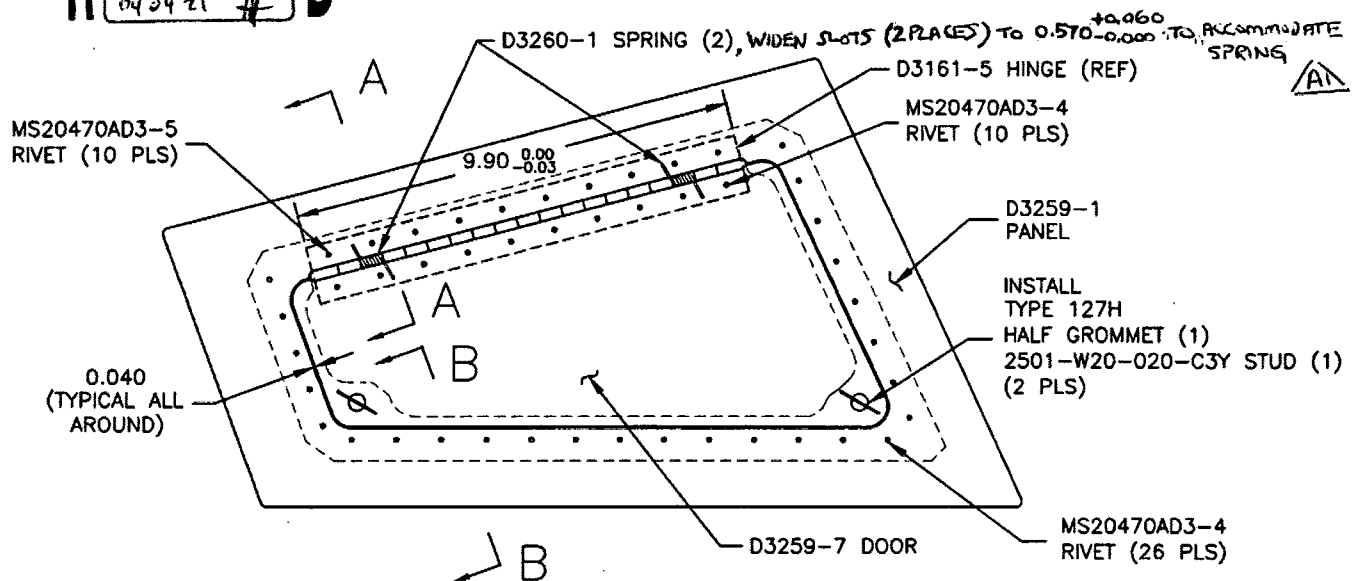
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	CP # 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED
04 24 21 #



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

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WORK ORDER
NO. 40440

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

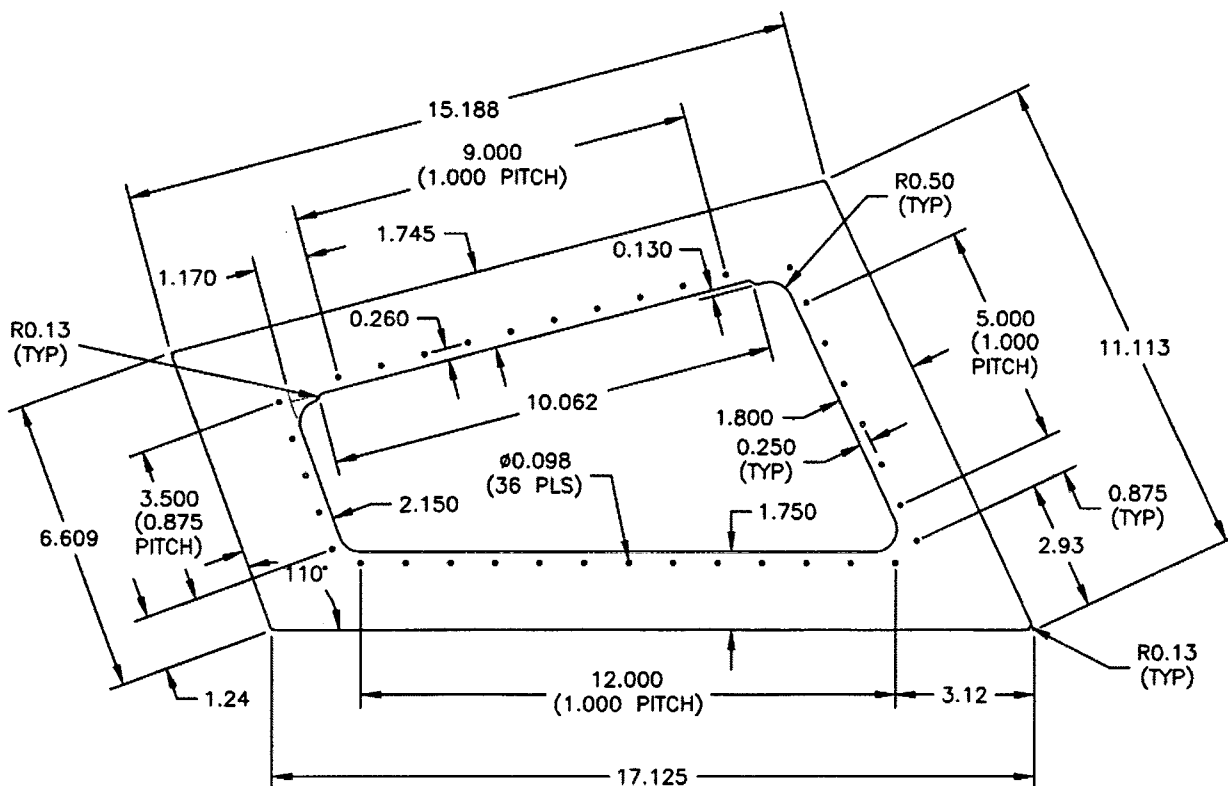
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

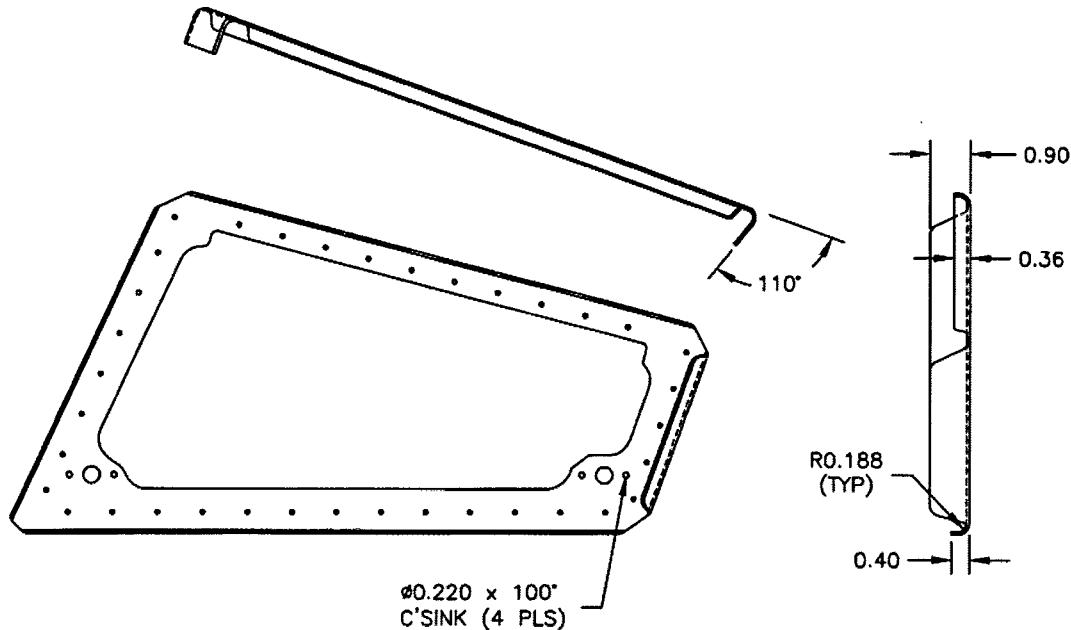
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DART

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CHECKED H	APPROVED H	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 41744

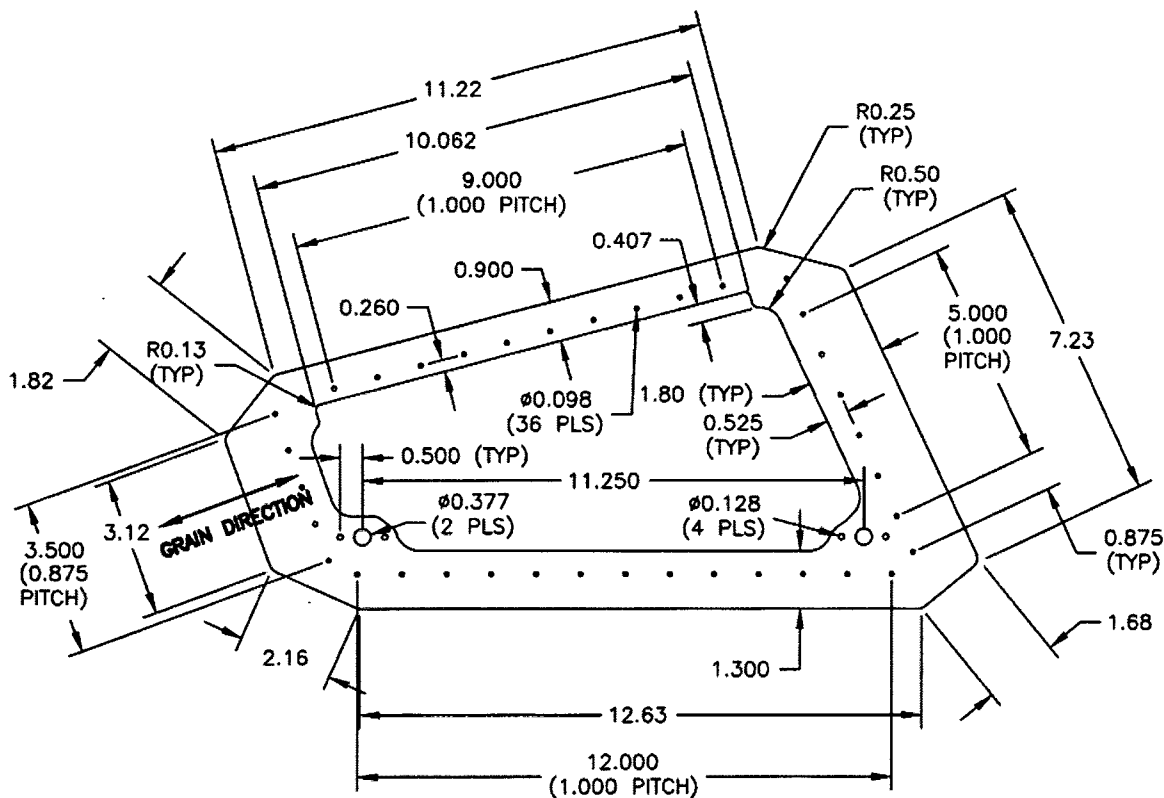
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.14 [Signature]

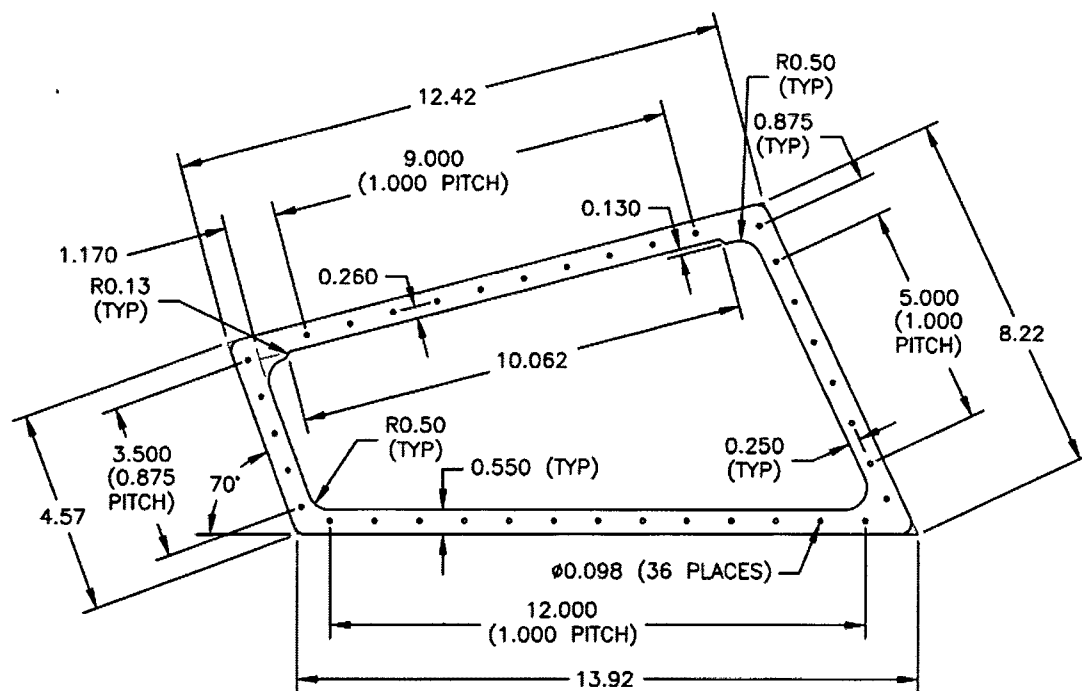
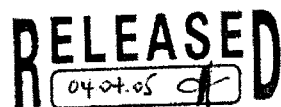


D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

- 1) MANUFACTURE PER "D3259-A5.DWG"
2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4N
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

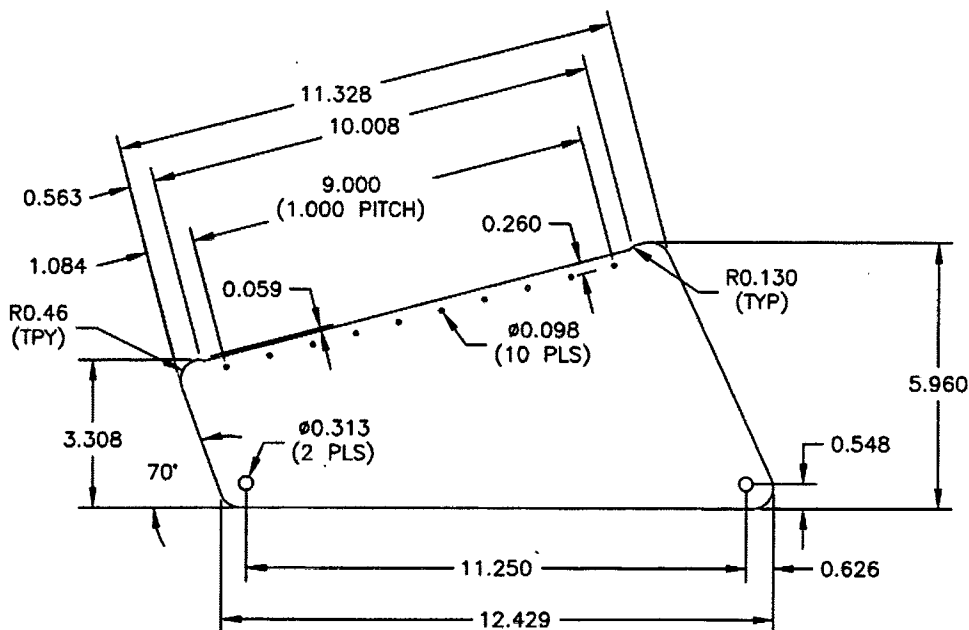
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 *[Signature]*



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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